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D4640-15
Job Sheet 201526



Part No: D4640-15

Job Qty: 3 pcs

Part Name: Ceiling Protector



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/7/19

Job Tracking No:

Due Date: 10/22/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D SHEETS 8,9 IPP REV:A 12.05.08 NEW ISSUE DD VERF:EC IPP REV:B 12.10.17 AS PER REV.B VERF:JLM

Ship Via:

untracked order 20040

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	3 pcs	10/22/19	10/22/19	0.17	0.85	Waterjet - Flow		<i>DC19/10/20</i>
110	QC 2	3 pcs	10/22/19	10/22/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		<i>DC19/10/20</i>
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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120 QC 8	3 pcs	10/22/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
130 Packaging 3-1 - Stock - B4B	3 pcs	10/22/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	

OCT 21 2019 4:09 PM
DAS
9-89

10/7/2019

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				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	OAS
				Packaging 3 - 35 - B4B	21 OCT 22 2019
				Packaging 3 - 36 - B4B	21 OCT 22 2019
140 QC 21 - SA	3 pcs	10/22/19	0.00 0.00	QC 21 - SA - 21	OAS
				QC 21 - SA - 70	21 OCT 22 2019
				QC 21 - SA - 53	21 OCT 22 2019
Part Op 110 - QC2- Inspect parts off machine FAI/FAIB Descriptions: 120 - QC8- Inspect parts - second check 130 - Identify as per dwg & Stock Location: _____ 140 - Receive & Inspect for Damage & Mat'l Certs					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
MLEXS.093-F6006-07	GE Plastics Lexan Sheet (Light Grey)	48 sf (16 ea)	100-Waterjet - Flow - 1	5054824	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Waterjet - Flow - 1	MLEXS.093-F6006-07	48	1,166	0	
Part Specifications					
Specifications could not be found.					

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DART AEROSPACE LTD		Work Order: 201526
Description: Ceiling Protector		Part Number: D4640-15
Inspection Dwg: D4640	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.80	+/-0.030	18.80	/		V.D.C. 02	
22.03	+/-0.030	22.03	/		Typical	
20.06	+/-0.030	20.06	/			
13.06	+/-0.030	13.06	/			
3.60	+/-0.030	3.60	/			
8.09	+/-0.030	8.09	/			
20.86	+/-0.030	20.86	/			
3.11	+/-0.030	3.11	/			
7.27	+/-0.030	7.27	/			
5.10	+/-0.030	5.10	/			
4.85	+/-0.030	4.85	/			
13.06	+/-0.030	13.06	/			
1.50	+/-0.030	1.50	/			
5.00	+/-0.030	5.00	/			
57.46	+/-0.030	57.46	/			
82.37	+/-0.030	82.37	/			
Ø8.13	+0.012/-0.001	Ø8.129	/			
6.77	+/-0.030	6.77	/			
5.72	+/-0.030	5.72	/			
6.13	+/-0.030	6.13	/			
2.21	+/-0.030	2.21	/			
0.88	+/-0.030	0.88	/			
7.78	+/-0.030	7.78	/			
7.47	+/-0.030	7.47	/			
Ø0.375	+0.006/-0.001	Ø0.374	/			
9.73	+/-0.030	9.73	/			
21.00	+/-0.030	21.00	/			
31.28	+/-0.030	31.28	/			
4.00	+/-0.030	4.00	/			
27.23	+/-0.030	27.23	/			
22.28	+/-0.030	22.28	/			
20.36	+/-0.030	20.36	/			
0.093	+/-0.010	0.093	/		DAS 43	

Measured by: <i>DN</i>	Audited by: 9-89	Preliminary Approval:
Date: 19/10/20	Date: OCT 21 2015	Date:

Rev	Date	Change	Revised by	Approved
A	12.09.26	New Issue	KJ	
B	13.02.27	Dwg Rev updated	KJ	



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

DISPOSITION		DEPARTMENT/PROCESS			
Job: _____	Rework ☐	Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐
Part No. _____	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐
	Use-as-is ☐	Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier ☐
					Quality ☐
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS1042)	
Description Work Order Deviation		Disposition			
Root Cause		FAULT CATEGORY			
Operator ☐	Pressure/Forced ☐	Contamination ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Manufacturing Process ☐	Bending ☐	Misaligned/off center ☐	Folio/Program ☐	Outside Tolerance ☐	
Equip/Tooling ☐	Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐	
Handling/Preservation ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Finish ☐	
Material ☐	Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Product Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Misread ☐	
Process Improvement ☐	Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐		
Human Factors ☐	Other/Details: _____				